

Work Order ID 76747

76747

Page 1

Monday, November 21, 2011 10:19:01 AM

Item ID: D2661-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 11/21/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/10/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: 

Date: 11/11/21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev E								

100

0.00

100

HAAS 1

*HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program part number and batch number.

Program part number and batch number
MACHINE AS PER DWG AND FOLIO FB073

FOLIO REV: AA
DWG REV: E

0.00

Y.A 11/12/09

SL 11-12-10



110

0.00

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

Machine Keyway and inspect per attached dimension sheet

0.00

Y.A 11/12/09

SL 11-12-10



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8xØ m-11/12/12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 76747

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Page 3

Monday, November 21, 2011 10:19:01 AM

Item ID: D2661-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, LH Fwd Aft Out 206
Start Date: 11/21/2011 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 1/10/2012 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat		0.00							
Powder Coating									
	Memo								
	START TIME: 1:40								
	FINISH TIME: 3200F								
	OVEN TEMPERATURE: 250								
160	QC3- Inspect Part Finish	0.00							
160									
QC		0.00							
Quality Control	Memo								
170	Identify as per dwg & Stock Location: 435	0.00							
170									
Packaging		0.00							
Packaging	Memo								

8x M-11/12/13

8x f 11/12/13
COUNTED

11/12/13 J/S

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 76747***76747***

Page 4

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 11/21/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/10/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

QC21- Final Inspection - Work Order Release

0.00

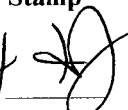
180

QC

Memo

0.00

Quality Control

11/12/14 MK
11-12-13

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Monday, November 21, 2011 10:19:05 AM

Page 1

Work Order ID: 76747

76747

Parent Item: D2661-1

D2661-1

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 11/21/2011

Required Date: 1/10/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	134.0000	1	8			
D6101-003									**				
Saddle Billet, 7075													

Location	Loc Qty	Loc Code
MAT040	105	
72226	8	
73775	36	
73780	7	
74650	54	
MAT44	29	
72226	2	
73769	1	
→ 74680	26	

8.0 B-A 11/2/09

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 76747
Description: 206 Saddle, Outboard, Left side	Part Number: D2661-1
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.133	.128	.129	.128		
B	0.100	0.140		0.125	.121	.121	.121		
C	1.125	1.145		1.135	1.135	1.135	1.136		
D	0.615	0.685		0.685	0.685	0.685	0.685		
E	0.240	0.260		0.256	.253	.252	.252		
F	1.313	1.343		1.328	1.328	1.328	1.327		
G	0.210	0.230		0.228	.227	.226	.226		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.576	1.576	1.576	1.575		
K	0.235	0.240		0.237	0.237	0.237	0.237		
L	0.100	0.120		0.109	.110	.110	.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		0.512	0.512	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.316	0.316	0.316	0.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.796	.798	.798		
W	0.540	0.560		.548	.548	.548	.548		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.912	0.932		.919	.920	.921	.921		
AA	0.490	0.510		.499	.500	.498	.498		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: B.A
Date: 11/12/09

Audited by: [Signature]
Date: 11/12/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

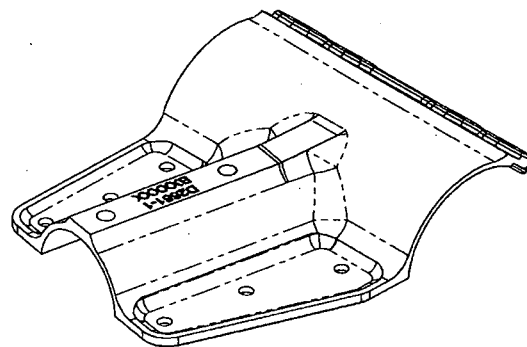
DART AEROSPACE LTD	Work Order: 76747
Description: 206 Saddle, Outboard, Left side	Part Number: D2661-1
Inspection Dwg: D2661 Rev. <i>DE</i>	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

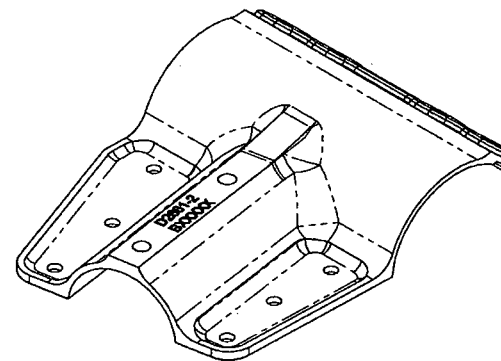
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.100	0.140		1.28 1.28	1.27	1.26	1.26		
B	0.100	0.140		1.20	1.21	1.20	1.19		
C	1.125	1.145		1.136	1.136	1.134	1.133		
D	0.615	0.685		0.685	0.685	0.685	0.685		
E	0.240	0.260		0.252	0.252	0.250	0.251		
F	1.313	1.343		1.327	1.327	1.324	1.323		
G	0.210	0.230		0.226	0.226	0.222	0.220		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.577	1.577	1.575	1.574		
K	0.235	0.240		0.237	0.237	0.237	0.237		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		0.512	0.512	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.316	0.316	0.316	0.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.798	0.797	0.797	0.796		
W	0.540	0.560		0.549	0.550	0.550	0.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.912	0.932		0.920	0.920	0.921	0.921		
AA	0.490	0.510		0.497	0.499	0.500	0.499		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>SL</i>	Audited by: <i>am</i>
Date: 11-12-010	Date: 11/12/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	<i>MA</i>



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 26747

211-11-21

RELEASED
2011-11-16

REV.	DESCRIPTION	BY	DATE
E	REDRAW & REFORMAT DWG; 0.887 WAS 0.547 (B8-2,B8-4). REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25

DESIGN	<i>JP</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>JP</i>	KENT, WA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>JP</i>	D2661	SHEET 1 OF 5
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	SADDLE, OUTSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

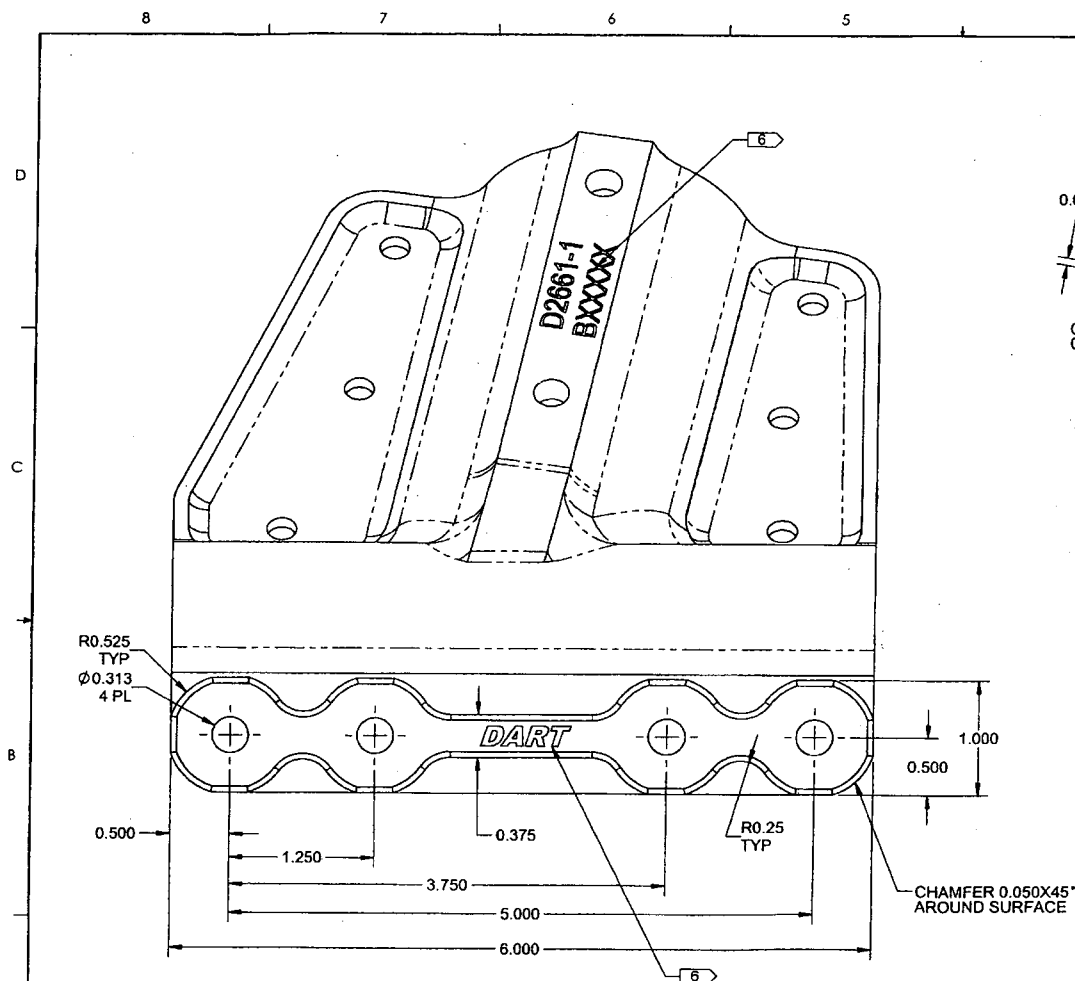
W/O:		WORK ORDER CHANGES					
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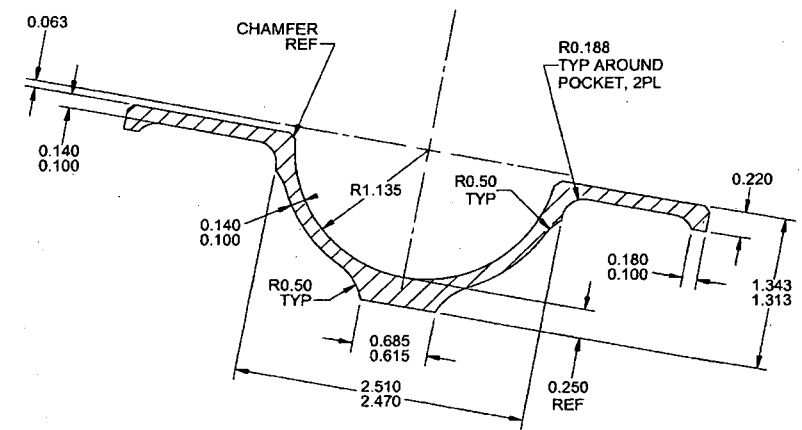
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NOTE: Date & initial all entries



VIEW B-B
SCALE 1.5X
VIEW ROTATED



VIEW A-A
SCALE 1.5X

76747

RELEASED
R 2011-11-16

DESIGN	<i>D</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>RS</i>	KENT, WA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D2661	SHEET 3 OF 5
APPROVED	<i>INP</i>	TITLE	SCALE
DE APPR.	<i>#</i>	SADDLE, OUTSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, WHO IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

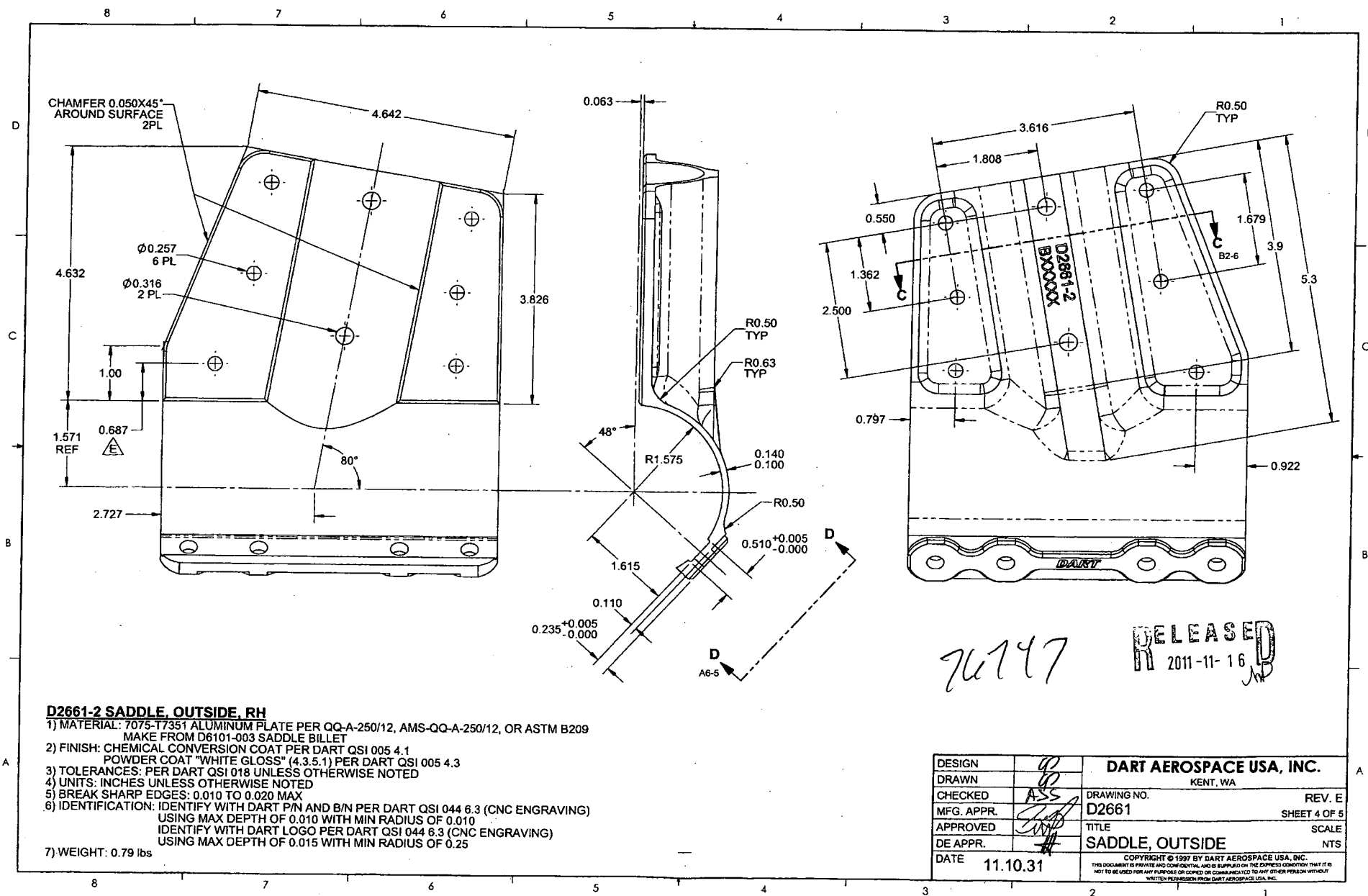
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DRAWN	g	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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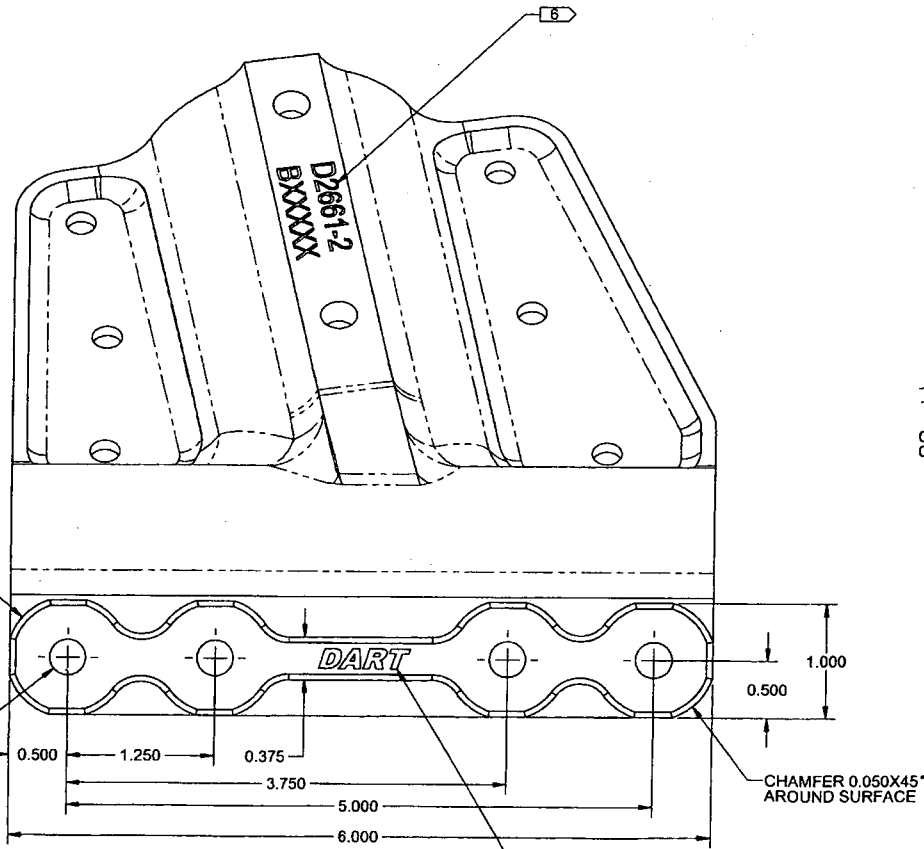
8 7 6 5 4 3 2 1

D

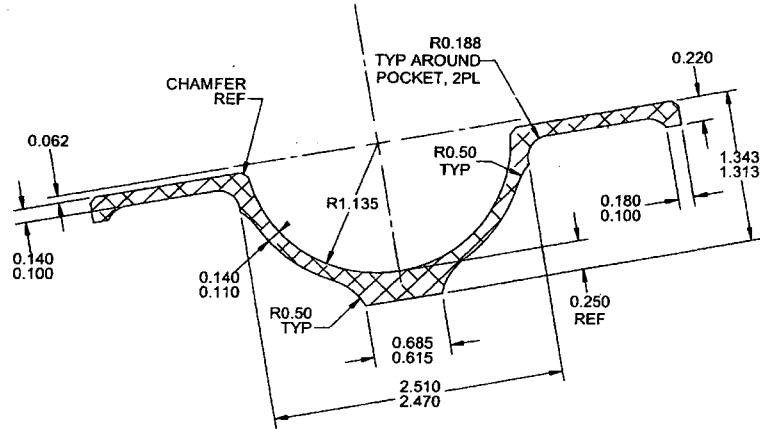
C

B

A



VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



SECTION C-C C1-4
SCALE 1.5X

76747

RECEIVED
2011-11-16

DESIGN	GP	DART AEROSPACE USA, INC.	
DRAWN	GP	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	WJP	D2661	SHEET 5 OF 5
APPROVED	WJP	TITLE	SCALE
DE APPR.	WJP	SADDLE, OUTSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

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